303 R 0.750"

Work Order ID 78193

January-02-12 10:10:21 AM

78193

Item ID: D3454-3

Revision ID:

Item Name: Bushing

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 02/01/2012 **Start Qty:** 24.00 *24*

Required Date: 31/01/2012 **Req'd Qty:** 24.00 *24*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** M.L.J **Date:** 12/01/02 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3454	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** 1-TURN AS PER FOLIO FA571 & DWG D3454 ,FOLIO REV: AA DWG REV: B 2-DEBURR AS REQUIRED	0.00 0.00				24	0		DA 12/01/10
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				24	0		DA 12/01/10
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	12/1/11			24	Ø		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ________ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 78193

January-02-12 10:10:21 AM

78193

Item ID: D3454-3

Revision ID:

Item Name: Bushing

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 02/01/2012 **Start Qty:** 24.00 *24*

Required Date: 31/01/2012 **Req'd Qty:** 24.00 *24*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Identify as per dwg & Stock Location ST 44	0.00							
	Memo	0.00				SP 12-01-12.			
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00						12/1/12	

MF 12-01-12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ________ Fault Category: ____________ NCR: Yes No DQA: _____ Date: __________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: __________ Date: __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

January-02-12 10:10:25 AM

Work Order ID: 78193 *78193*

Parent Item: D3454-3 *D3454-3*

Parent Item Name: Bushing

Start Date: 02/01/2012 **Required Date:** 31/01/2012

Start Qty: 24.00 **Required Qty:** 24.00

Comments: IPP rev. A 05.11.17 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 *M303R0.750* 303 Round Bar 0.750		Purchased	No			100	f	22.4710	0.06 **	1.515789 1.285'		SJ 12/01/10	

Location	Loc Qty	Loc Code	
MAT028	22.471		
117328	13.242		
117798	4.004		
118509	4.08		
119346	1.145		
120145			1.285'

M303RO.750
M120145

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	78193
Description: Bushing	Part Number:	D3454-3
Inspection Dwg: D3454 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	Ø0.316	✓		SL02/SL08	
Ø0.435	+0.000/-0.005	Ø0.433	✓		"	
0.400	+0.005/-0.000	0.4025	✓		"	
0.060	+0.010/-0.000	0.064	✓		"	
Ø0.75	+0.008/-0.001	Ø0.7495	✓		"	

Measured by:	[signature]	Audited by:	[signature]	Prototype Approval:	N/A
Date:	12/01/10	Date:	12/1/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	10.03.31	Dimension 0.060 was 0.60	KJ	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

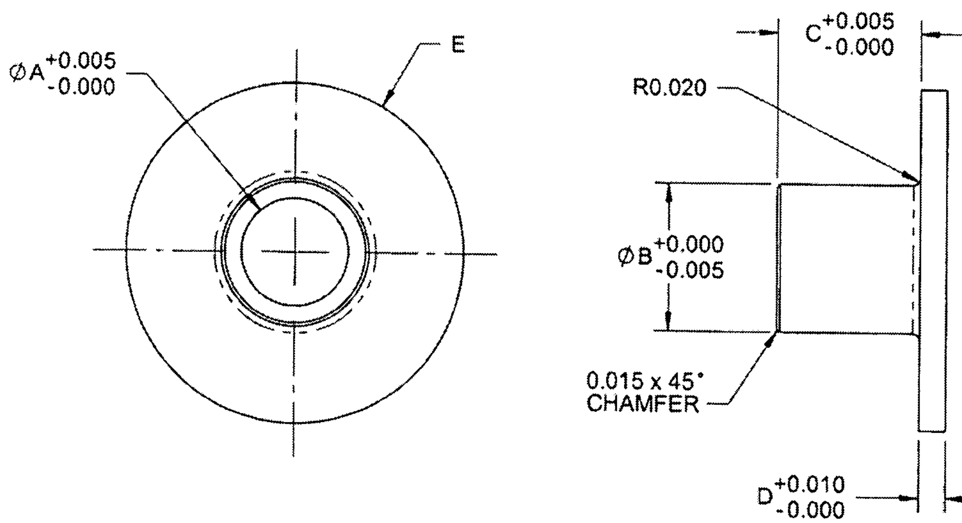
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3454 — REV. B — SHEET 1 OF 1
DATE 05.12.05		TITLE BUSHING — SCALE 2:1

A	05.09.02	NEW ISSUE
B	05.12.05	REVISE -5/-7

RELEASED 05.12.09



D3454-X

UNCONTROLLED COPY

NO 78193 M.C.J 12/01/02

1) SPECIFICATION: **D3454-X BUSHING**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75

B B

NOTES:

1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
2) FINISH: NONE
3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries